

Work Order ID 153270

Tuesday, November 15, 2016 11:17:54 AM



153270

PRELIMINARY ISSUE

Ship DEC 16TH

Page 1

Item ID: 647.7333 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Lower Cutter Removable Provisions
 Start Date: 12/8/2016 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 12/8/2016 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: VS DAS 21 9-89 Date: 12/11/16 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
100	100 <u>100</u> <u>MPP-195</u>	<u>DEC 15 2016</u>							
100	Document Control	0.00							
DC	DOCUMENT CONTROL								
Doc.Control -USB or Paperwork	Memo	0.00							
	Photocopy bluefile & type labels per PPP 647.7333								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

DEC 19 2016

DEC 15 2016

DEC 19 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
						QC / QA Coordinator Approval			
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Work Order ID 153270

Tuesday, November 15, 2016 11:17:54 AM

153270

Page 2

Item ID: 647.7333

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Lower Cutter Removable Provisions

Start Date: 12/8/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/8/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP 647.7333 Location <u>FG109</u>								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

DAS
27 28
9-89 9-89

DEC 19 2016

DAS
21
9-89

DEC 20 2016

POSITIVE RECALL
EFFECTIVE 12-11-18 AUTH [Signature]
RELEASED _____ DATE _____
RD16-1006-01DAS
21
9-89

DEC 20 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Picklist Print

Tuesday, November 15, 2016 11:17:54 AM

Page 1

Work Order ID: 153270

153270

Parent Item: 647.7333

647 7333

Parent Item Name: Lower Cutter Removable Provisions

Start Date: 12/8/2016

Required Date: 12/8/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 16.09.28 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
601.3902 *601 3902* Eye Bolt		Manufactured	No				Each	1.0000		1			
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					ckk101			1					
					147212			1					
647.7501 *647 7501* Lower Cutter Assembly		Manufactured	No				Each	0.0000		1			
647.7702 *647 7702* Strut Assembly		Manufactured	No				Each	3.0000		2			
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					CCK076			3					
					146723			3					
647.0112 *647 0112* Strut Bracket		Manufactured	No				Each	79.0000		2			
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					CCK107			54					
					150114			42					
					151352			12					
					CCK108A			25					
					150895			15					
					151894			10					

Handwritten mark resembling a stylized 'S' or '5'.

Handwritten blue ink: "P/4 M"

Handwritten blue ink: "1X B153190"

Handwritten blue ink: "2X B146723", "1X B153192"

Handwritten blue ink: "DAS 6 9-89"

Handwritten blue ink: "DEC 15 2016"

Handwritten blue ink: "DAS 27 9-89"

Handwritten blue ink: "DAS 28 9-89"

Handwritten blue ink: "DAS 27 9-89", "DAS 28 9-89"

Handwritten blue ink: "DAS 27 9-89"

Handwritten blue ink: "DAS 27 9-89"

Handwritten blue ink: "DAS 27 9-89"

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

Page 2

Tuesday, November 15, 2016 11:17:54 AM

Work Order ID: 153270

153270

Parent Item: 647.7333

647 7333

Parent Item Name: Lower Cutter Removable Provisions

Start Date: 12/8/2016

Required Date: 12/8/2016

Start Qty: 1.00

Required Qty: 1.00

AN44-5A Purchased No

Each 27.0000 2

AN44-5A

Eyebolt

**

DAS
6
9-89

DAS
28
DEC 15 2016 9-89

Location	Loc Qty	Loc Code
ST339	27	
m135127	3	
m135774	12	
m136047	12	

153953

AN665-34R Purchased No

Each 23.0000 2

AN665-34R

Clevis

**

DAS
6
9-89

DAS
28
DEC 15 2016 9-89

Location	Loc Qty	Loc Code
ST330	23	
M135603	3	
M135948	20	

2

AN3-11A Purchased No

Each 96.0000 2

AN3-11A

Bolt

**

DAS
6
9-89

DAS
28
DEC 15 2016 9-89

Location	Loc Qty	Loc Code
ST349	96	
m135390	2	
m135767	94	

2

AN4C7A Purchased No

Each 96.0000 2

AN4C7A

BOLT

**

DAS
6
9-89

DAS
28
DEC 15 2016 9-89

Location	Loc Qty	Loc Code
OVER002	70	
m135864	70	
ST345	26	
m135470	26	

2

Tuesday, November 15, 2016 11:17:54 AM

Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
		OTHER : _____			

Picklist Print

Tuesday, November 15, 2016 11:17:54 AM

Work Order ID: 153270

153270

Parent Item: 647.7333

647 7333

Parent Item Name: Lower Cutter Removable Provisions

Start Date: 12/8/2016

Required Date: 12/8/2016

Start Qty: 1.00

Required Qty: 1.00

NAS6603-12 Purchased No

Each 136.0000 4

NAS6603-12

Bolt

**

DEC 15 2016

DAS 6 28
9-89 9-89

Location

Loc Qty

Loc Code

st552

136

123900

124

m130388

12

NAS6603-16 Purchased No

Each 81.0000 4

NAS6603-16

Bolt

**

DEC 15 2016

DAS 6 28
9-89 9-89

Location

Loc Qty

Loc Code

st552

81

m128199

19

m130388

12

m133523

50

MS21042-08 MS21042L08 Purchased No

Each 0.0000 2

MS21042-08

USE MS21042L08

**

DEC 15 2016

DAS 6 28
9-89 9-89

MS21042-3 MS21042L3 Purchased No

Each 0.0000 2

MS21042-3

Nut

**

DEC 15 2016

DAS 6 28
9-89 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
		OTHER : _____			

Picklist Print

Tuesday, November 15, 2016 11:17:54 AM

Work Order ID: 153270

153270

Parent Item: 647.7333

647 7333

Parent Item Name: Lower Cutter Removable Provisions

Start Date: 12/8/2016

Required Date: 12/8/2016

Start Qty: 1.00

Required Qty: 1.00

MS21042L4

Purchased

No

Each

1,964.000

2

MS21042L4

Nut

DEC 15 2016
DAS 6 28
9-89 9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

FP001

34

m133363

34

GA

204

m135058

204

OVER007

500

m135979

500

ST303

1226

m135774

226

m135864

1000

DEC 15 2016

DAS 6 28
9-89 9-89

AN316C4R

Purchased

No

Each

13.0000

2

AN316C4R

Nut, Jam

DAS
27
9-89

Location

Loc Qty

Loc Code

ST331

13

m135840

13

136/92

MS27039-08-13

Purchased

No

Each

72.0000

2

MS27039-08-13

Screw

DEC 15 2016

DAS 6 28
9-89 9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST278

72

124326

72

2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
186 186				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
OTHER : _____					

Picklist Print

Tuesday, November 15, 2016 11:17:54 AM

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Work Order ID: 153270

153270

Parent Item: 647.7333

647 7333

Parent Item Name: Lower Cutter Removable Provisions

Start Date: 12/8/2016

Required Date: 12/8/2016

Start Qty: 1.00

Required Qty: 1.00

NAS1149FN832P

Purchased

No

Each

1,463.000

4

NAS1149FN832P

Washer

DAS
27
9-89

Location

Loc Qty

Loc Code

GA

1285

M135058

1285

ST263

178

M135603

178

Each

1,167.000

DAS
6
9-89

DEC 15 2016

DAS
28
9-89

NAS1149C0432R

Purchased

No

Each

1,167.000

NAS1149C0432R

WASHER

DAS
27
9-89

Location

Loc Qty

Loc Code

GA

373

m134676

373

ST266

794

m135979

794

Each

1,641.000

DAS
6
9-89

DEC 15 2016

DAS
28
9-89

NAS1149F0532P

Purchased

No

Each

1,641.000

NAS1149F0532P

Washer

DAS
27
9-89

Location

Loc Qty

Loc Code

ST260a

600

m133725

600

ST262

1041

18057

1041

DAS
6
9-89

DEC 15 2016

DAS
28
9-89

Tuesday, November 15, 2016 11:17:54 AM

Shop Packet Print

Page 5

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		

Root Cause				FAULT CATEGORY			
Environment ☐	☐	No Re-verification ☐	☐	Pressure/Forced ☐	☐	Temperature/Cure ☐	☐
Design ☐	☐	Operator ☐	☐	Bending ☐	☐	Set-up ☐	☐
Doc/Data ☐	☐	Offset/Setup ☐	☐	Centre Not Concentric ☐	☐	BOM/Route ☐	☐
Equip/Tooling ☐	☐	Supplier ☐	☐	Cracks ☐	☐	Broken/Damage/Defect ☐	☐
Handling/Pre ☐	☐	Training ☐	☐	Crimp/Kink/Ripple/Wave ☐	☐	Inspection Incomplete/Unqualified ☐	☐
Material ☐	☐	Use for Testing ☐	☐	Cuffs ☐	☐	Contamination ☐	☐
Internal Transport ☐	☐	Poor Information ☐	☐	Crushing ☐	☐	Countersink ☐	☐
Tribal Knowledge ☐	☐	Rushing ☐	☐	Heat Treat ☐	☐	Cut Too Short ☐	☐
LOA ☐	☐	Product Improvement ☐	☐	Wave/Twist in Tube ☐	☐	Instructions Incomplete/Unclear ☐	☐
Substation ☐	☐	Process Improvement ☐	☐	Marks/Chatter ☐	☐	Drill Holes ☐	☐
Past Expiry Date ☐	☐	Manufacturing Process ☐	☐	OTHER : _____ _____ _____			
Misidentified ☐	☐	Past Due ☐	☐				



SUBJECT:
Manufacturing Process Procedure
EC-135 CCK Configuration Management

DOCUMENT NO:
MPP-195
Rev. N/C
12/15/16

Table 15: Universal Wiper Deflector (WD) Assembly, 647.7341

FIND #	PART #	DESCRIPTION	QTY
4	647.1601	WIPER DEFLECTOR ASSY, AFT	1
5	647.1610	WIPER DEFLECTOR, FWD	1
29	647.1914	BRACKET	1
30	647.1602	DOUBLER ASSY	1
35	647.3201	GROUNDING CABLE ASSY	1
47	601.1324	BOLT	1
52	601.2973	LOCKNUT	1
53	601.2943	LOCKNUT	3
60	601.2525	SCREW	1
63	601.2198	SCREW	3
67	601.1622	SCREW	4
72	601.2999	SCREW	3
85	601.2764	WASHER	2
86	601.1607	WASHER	10
89	601.2375	WASHER	3

SHOP COPY
RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 153270
[Signature]

DEC 16 2016

Work Order ID 153270***153270***

Page 1

Item ID: 647.7333

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: EC135 T1/P1 Lower Cutter Removable Provisions

Start Date: 12/8/2016 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 12/8/2016 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start ***NR1***

QC: Date: SPC (Y/N): Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

MPP-195

N/C

100

Document Control

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile & type labels per PPP 647.7333

DAS
21
9-89

DEC 16 2016

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

Marie Lajeunesse

From: Kim Johnston
Sent: Friday, December 16, 2016 9:51 AM
To: Marie Lajeunesse
Subject: FW: EC135 CCK MPP & IIN corrections

Thanks,

Kim Johnston
*Engineering Clerk
Document Administrator*

DART AEROSPACE
T 1 613 632-5200 > ext. 226
F 1 613 632-9311



From: Sian Willems
Sent: Monday, December 12, 2016 9:21 AM
To: Lisa McMachen <lcmachen@dartaero.com>; Kim Johnston <kjohnston@dartaero.com>
Subject: RE: EC135 CCK MPP & IIN corrections

Go ahead and load. A corrected version will follow once DaveM makes the updates.

SIAN WILLEMS
Customer Support Manager

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From: Lisa McMachen
Sent: Monday, December 12, 2016 8:26 AM
To: Kim Johnston <kjohnston@dartaero.com>; Sian Willems <swillems@dartaero.com>
Subject: FW: EC135 CCK MPP & IIN corrections

Hi Sian,
Kim says that the paperwork is not jiving...can we load the attached documents to the website as discussed on Friday? Please see the attached email.

Thanks,
Lisa McMachen

From: Sian Willems
Sent: Monday, December 12, 2016 7:21 AM



REFERENCE ONLY

SUBJECT:
Manufacturing Process Procedure
EC-135 CCK Configuration Management

DOCUMENT NO:
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Rev. N/C
12/15/16

Table 12: T1/P1 LC Removable Provisions Kit, 647.7333

FIND #	PART #	DESCRIPTION	QTY
2	647.7501	LOWER CUTTER ASSY	1
10	647.7702	STRUT ASSY	2
14	647.0112	STRUT BRACKET	2
38	601.3121	EYE BOLT AN44-SA	2
40	601.3119	CLEVIS AN66S34R	2
46	601.2826	BOLT AN3-H1A	2
48	601.2669	BOLT AN4C7A	2
49	601.1500	BOLT NAS6603-12	4
50	601.3130	BOLT NAS6603-16	4
52	601.2973	LOCKNUT MS21042-08	2
53	601.2943	LOCKNUT MS21042-3	2
54	601.3209	LOCKNUT MS21042L4	2
55	601.3128	NUT AN316C4R	2
61	601.2988	SCREW MS27039-08/3	2
85	601.2764	WASHER NAS1149F0832P	4
87	601.3663	WASHER NAS1149C0432R	4
88	601.3126	WASHER NAS1149F0532P	2